

Work Order ID 69043

Wednesday, April 27, 2011 11:24:38 AM



Page 1

Item ID: D3911-5

Accept



Setup Start



Revision ID:

Stop



Item Name: Basket Stud Plate

Start Date: 4/27/2011 Start Qty: 12.00



Cust Item ID:

Required Date: 5/3/2011 Req'd Qty: 12.00



Customer:

Reference:

Approvals:

Process Plan:

Date: 11-04-27

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3911	D

100

0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

Cut as per dwg D3911

Prog Rev: PDwg Rev: D

304.175

Deburr as required

B11-4-28

(13)

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B11-4-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



Work Order ID 69043




Wednesday, April 27, 2011 11:24:38 AM



Page 2

Item ID: D3911-5 Accept  Setup Start 
Revision ID:
Item Name: Basket Stud Plate Stop 
Start Date: 4/27/2011 Start Qty: 12.00  Cust Item ID:
Required Date: 5/3/2011 Req'd Qty: 12.00  Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120  QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00				<u>43</u>			
130  Packaging Packaging	Identify as per dwg & Stock Location: <u>91</u> Memo	0.00 0.00							<u>11/4/28</u> <u>130</u>
140  QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							<u>11/4/29</u> <u>13</u> <u>11-09-28</u> <u>13</u>

W/O:		WORK ORDER CHANGES					
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Picklist Print

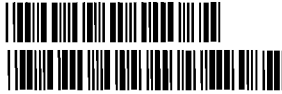
Wednesday, April 27, 2011 11:24:43 AM

Page 1

Work Order ID: 69043

Parent Item: D3911-5

Parent Item Name: Basket Stud Plate



Start Date: 4/27/2011

Required Date: 5/3/2011

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP RevA: new issue DD 09.11.17 verified by:EC
AS PER REV B 10-03-23 JLM VERIFIED BY:DD

IPP REV:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304S11GA

Purchased

No

100

sf

176.5000

0.0299

0.377684

15



B11-4-28

304/316 0.125 Sheet

Location

Loc Qty

Loc Code

MAT020

176.5

117494

176.5

117494

13

W/O:		WORK ORDER CHANGES					
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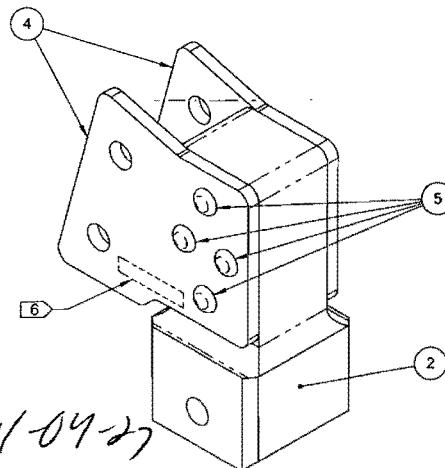
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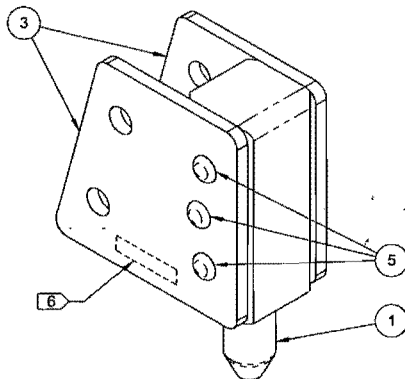
NOTE: Date & initial all entries

ITEM	QTY -041	QTY -043	P/N	DESCRIPTION
	X		D3911-041	BASKET INSTL STUD ASSY (LOWER)
		X	D3911-043	AFT EYEBOLT RECEIVER ASSY
1	1		D3911-1	BASKET INSTL STUD (LOWER)
2		1	D3911-3	AFT EYEBOLT RECEIVER
3	2		D3911-5	BASKET STUD PLATE
4		2	D3911-7	BASKET PLATE-EYEBOLT RECEIVER
5	3	4	MS20615-4M20	RIVET

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 69043



D3911-043 AFT EYEBOLT RECEIVER ASSY



D3911-041 BASKET INSTL STUD ASSY (LOWER)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N D3911-04X USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT -041: 0.63 lbs
-043: 0.99 lbs

RELEASED
2010-08-04

D	0.825 +0.000/-0.010 WAS 0.85 (B1-2).	MB	10.06.22
C	BOM: QTY (2): D4087-1 & MS21209-C610 REMOVED FROM -043 ASSY. WEIGHT UPDATED. D3911-3 REDESIGNED. D3911-043 & D3911-3 DETAIL UPDATED. MTL SPEC ADDED TO NOTES (SHT 2). DIM 0.375 WAS 0.400 (C3-3).	JPH	10.04.06
B	DIAMETER (B3-2) AND DIM ADDED (B2-2) & (C3-2)	JPH	10.03.16
A	NEW ISSUE	JPH	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	JPH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	JPH	DRAWING NO.	REV. D
MFG. APPR.	JPH	D3911	SHEET 1 OF 3
APPROVED	JPH	TITLE	SCALE
DE APPR.	JPH	AFT HARDPOINT, BASKET	NTS
DATE	10.06.22	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY FORM OR BY ANY MEANS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

D

C

B

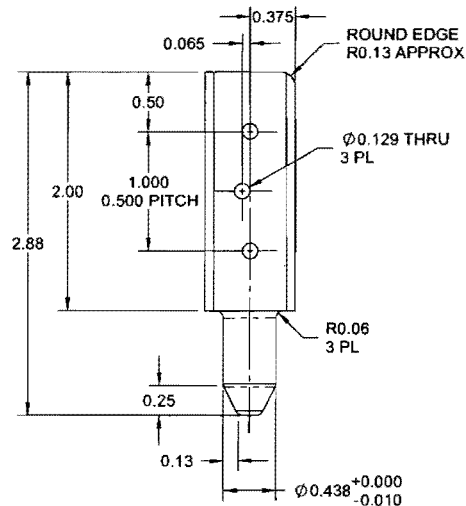
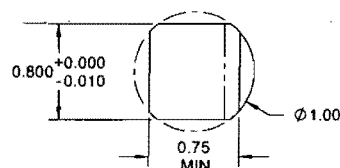
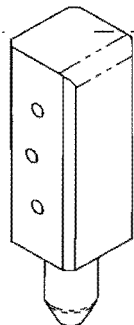
A

D

C

B

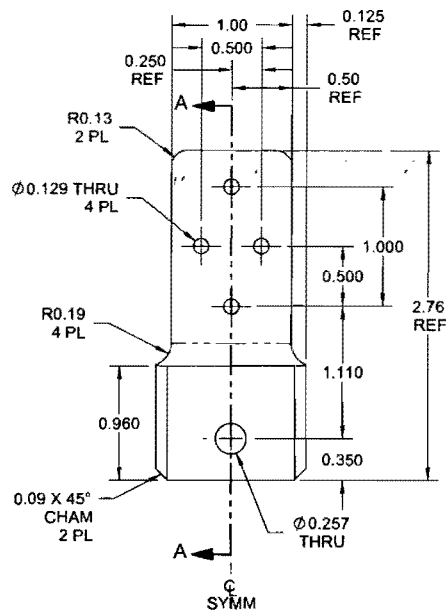
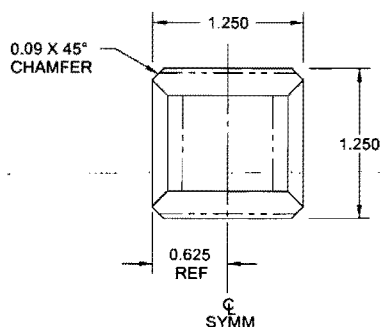
A



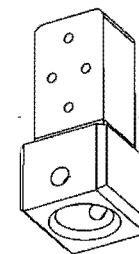
D3911-1 BASKET INSTL STUD (LOWER)

NOTES:

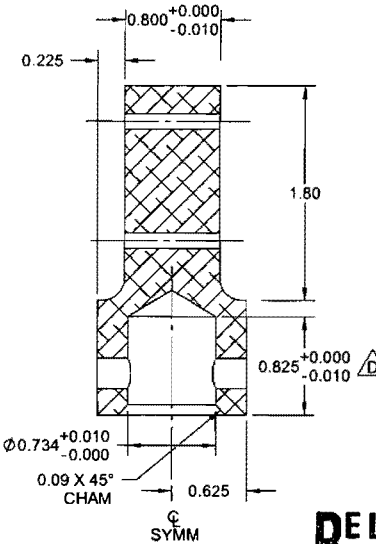
- 1) MATERIAL -1: 303/304/316 STAINLESS STEEL ROUND BAR, PER ASTM A276 OR ASTM A582 PER DART SPEC M303R OR M304R
- 3: 303/304/316 STAINLESS STEEL BAR, PER ASTM A276 OR ASTM A582 PER DART SPEC M303B OR M304B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY AT ASSEMBLY
- 7) WEIGHT -1: 0.36 lbs
-3: 0.71 lbs



D3911-3 AFT EYEBOLT RECEIVER








46060043



SECTION A-A

RELEASED
2010-08-04
MD

DESIGN	JPH	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV.
MFG. APPR.		D3911	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR. --		AFT HARDPOINT, BASKET	NTS
DATE	10.06.22	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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8 7 6 5 4 3 2 1

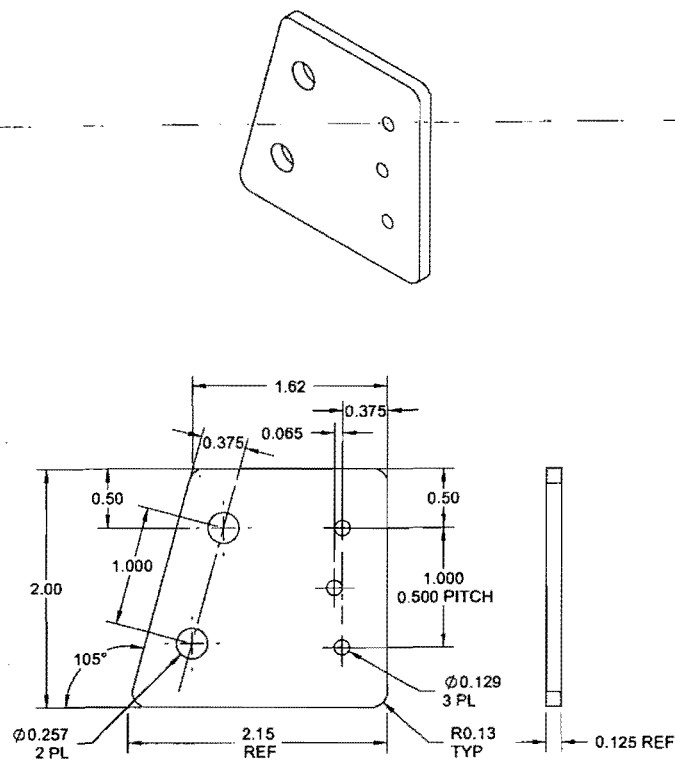
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

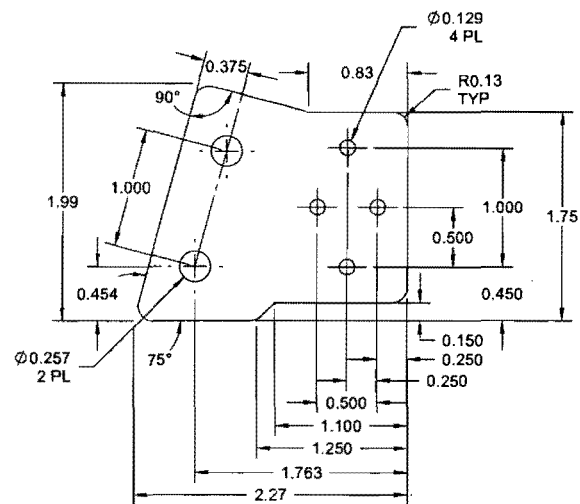
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NOTE: Date & initial all entries



D3911-5 BASKET STUD PLATE



D3911-7 BASKET PLATE-EYEBOLT RECEIVER

u1069043

NOTES:

- 1) MATERIAL -5 & -7: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B, 0.125 THK
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240
PER DART SPEC M304S11GA OR M303S11GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY AT ASSEMBLY
- 7) WEIGHT--5: 0.13 lbs
--7: 0.13 lbs

DESIGN	JPH	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D3911	SHEET 3 OF 3
APPROVED		TITLE	SCALE
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RELEASED
2010-08-06

W/O:		WORK ORDER CHANGES					
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